

# Work Order ID 84030

\*84030\*

Page 1

May-01-12 10:46:20 AM

Item ID: D205-778-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Comfort Seat, LH/RH

Stop \*NS2\*

Start Date: 01/05/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/02 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3800	B								
DSI 9508	A								
IIN D205-778	Rev B								
100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D205-778-011 CHG 003								
110	Pick Kit	0.00							
*110*									
Packaging	Memo	0.00							
Packaging									

SL

Sidell

MLJ 12-6-11  
(2)

(20) 12/6/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84030**

May-01-12 10:46:20 AM

**\*84030\***

Page 2

Item ID: D205-778-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Comfort Seat, LH/RH

Start Date: 01/05/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 2.00

**\*2\***

Customer:



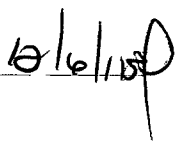
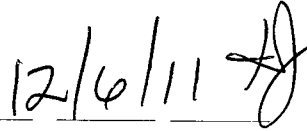
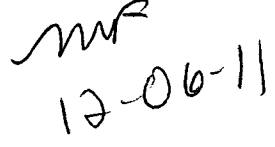
Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							
130 <b>*130*</b> Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D205-778-101 Location: <u>39</u> PPP Rev: <u>39</u>	0.00  0.00							
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-01-12 10:46:23 AM

Page 1

Work Order ID: 84030

\*84030\*

Parent Item: D205-778-011

\*D205-778-011\*

Parent Item Name: Comfort Seat, LH/RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC  
per DSI 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD6L

Purchased

No

110

Each

578.0000

16

32

\*\*

\*AN960JD6L \*

Washer

Location

Loc Qty

Loc Code

ST337A

578

5519

578

110

Each

250.0000

8

16

\*\*

BSP-42

\*RSP-42\*

Rivet

Purchased

No

Location

Loc Qty

Loc Code

ST281

200

121163

200

ST284

50

120930

50

110

Each

1.0000

16

2

\*\*

D3752-1

\*D3752-1\*

Seat Frame

Manufactured

No

Location

Loc Qty

Loc Code

ST252A

1

80365

1

110

Each

4.0000

2

\*\*

D3755-041

\*D3755-041\*

Seat Cushion

Manufactured

No

Location

Loc Qty

Loc Code

ST258A

4

81290

4

2

2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-01-12 10:46:24 AM

Work Order ID: 84030

\*84030\*

Parent Item: D205-778-011

\*D205-778-011\*

Parent Item Name: Comfort Seat, LH/RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 2.00

Required Qty: 2.00

D3756-041

Manufactured No

110 Each

4.0000

\*D3756-041\*

Cushion

\*\*

Location

Loc Qty

Loc Code

ST258A

4

81291

4

D3758-041

Manufactured No

110 Each

32.0000

\*D3758-041\*

Clamp

\*\*

Location

Loc Qty

Loc Code

ST458

32

82181

32

D3777-041

Manufactured No

110 Each

20.0000

\*D3777-041\*

Clamp

\*\*

Location

Loc Qty

Loc Code

ST458

20

73975

20

D3800-3-200

Manufactured No

110 f

98.1748

\*D3800-3-200\*

Hook and Loop Strip (2" Hard)

\*\*

Location

Loc Qty

Loc Code

ST064

98.1748

56393

38.1748

60044

60

1- Cut to length as per dwg (4x 6.00")

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Work Order ID: 84030

\*84030\*

Parent Item: D205-778-011

\*D205-778-011\*

Parent Item Name: Comfort Seat, LH/RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 2.00

Required Qty: 2.00

AN525-10R8

Purchased

No

110

Each

271.0000

8

16

\*AN525-10R8\*

Screw

\*\*

## Location

## Loc Qty

## Loc Code

ST345

271

119307

3

120986

68

121165

200

AN970-3

Purchased

No

110

Each

215.0000

8

16

\*AN970-3\*

Washers

\*\*

## Location

## Loc Qty

## Loc Code

ST344

215

117395

3

120308

6

120644

6

121163

200

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

16

\*AN960JD10\*

Washer

\*\*

11/11/2012

15x

11/11/2012

12/6/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-01-12 10:46:24 AM

Work Order ID: 84030

\*84030\*

Parent Item: D205-778-011

\*D205-778-011\*

Parent Item Name: Comfort Seat, LH/RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 2.00

Required Qty: 2.00

MS2104212

Purchased

No

100

Each

3,140.000

8

16

\*MS210421 3\*

\*\*

SL 01/05/12

Location

Loc Qty

Loc Code

ST300

3140

117441

16

117885

32

118451

5

118927

3

119017

1131

119075

138

121340

815

121444

1000

16 5.2

~~16 5.2~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

#### 4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

#### 5.0 PARTS LIST

Qty -011	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

\* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1  
REF TCCA STC: SH08-37  
REF FAA STC: SR02704NY  
REF EASA STC: EASA.IM.R.S.01518

## PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

## CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

## PARTS LIST

QTY	Part Number	Description
-011		
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

## INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

## UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY	Part Number	Description
-011		
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.03.02  
CERT. NO.: SH08-37  
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>qp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>h</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9508	SHEET 1 OF 2
APPROVED	<i>h</i>	TITLE	SCALE
DE APPR.	<i>h</i>	RIVET KIT	NTS
DATE	10.03.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	